

ATTACHMENT A

Clean Replacement/New Claims (entire set of pending claims)

Following herewith is a clean copy of the entire set of pending claims.

1. (amended) Method of producing mould parts on a string moulding apparatus comprising a moulding chamber between a squeeze plate and a pivoted squeeze plate in which both the squeeze plate and the pivoted squeeze plate can move in a direction towards each other and a direction away from one another comprising the steps of introducing a compressible particulate moulding material in the moulding chamber and then squeezing the moulding material by moving the squeeze plate and the pivoted squeeze plate towards one another, characterized by the step of controlling the velocity of the squeeze plate and the velocity of the pivoted squeeze plate independent from one another during the squeezing of the mould part.

2. (amended) Method according to claim 1, characterized by the step of controlling the velocity of the squeeze plate and the pivoted squeeze plate such that they move in the same direction during at least a part of the squeezing of the mould.

3. (amended) Method according to claim 2, characterized by the step of controlling the velocity of the squeeze plate and the pivoted squeeze plate such that either the squeeze plate or the pivoted squeeze plate is slowed down abruptly for creating a shock effect.

4. (amended) Method according to claim 2, characterized by the step of controlling the velocity of the squeeze plate and the pivoted squeeze plate such that the pivoted squeeze plate is reversed during the squeezing operation.

5. (amended) Method according to claim 2, characterized by the step of controlling the velocity of the squeeze plate and the pivoted squeeze plate such that they move

towards one another with different velocity during at least a part of the squeezing of the mould.

6. (amended) Method according to claim 1, characterized by the step of controlling the velocity of the squeeze plate and the pivoted squeeze plate such that they move towards one another with equal velocity during at least a part of the squeezing of the mould.

7. (amended) Method according to claim 1 characterized in that the velocity of the squeeze plate and the velocity of the pivoted squeeze plate are controlled according to a predetermined velocity versus time profile.

8. (amended) Method according to claim 1, characterized in that the velocity of the pivoted squeeze plate is controlled such that the pivoted squeeze plate is positioned at the moulding chamber front at the end of the squeezing of the mould.

9. (amended) String moulding apparatus for producing mould parts comprising a moulding chamber between a squeeze plate and a pivoted squeeze plate, in which mould parts are produced by introducing a compressible particulate moulding material in the moulding chamber and then moving the squeeze plate and the pivoted squeeze plate towards each other to squeeze the mould part

characterized in that the velocity of the squeeze plate and the velocity of the pivoted squeeze plate are controlled independently from one another during squeezing of the mould part.

10. (amended) Apparatus according to claim 9, characterized in that a first actuator driving the squeeze plate and a second actuator driving the pivoted squeeze plate are independently powered.

11. (amended) Apparatus according to claim 9, characterized in that a first hydraulic actuator driving the squeeze plate is powered by a first pump and a second hydraulic actuator driving pivoted squeeze plate is powered by a second pump 31

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12. (amended) Apparatus according to claim 10, further comprising a first sensor for producing a signal corresponding to the velocity of the squeeze plate and comprising a first sensor for producing a signal corresponding to the velocity of the pivoted squeeze plate.

method
13. (amended) Apparatus according to claim 12, further by comprising a controller which receives the signals from the first and second sensors and controls the velocity of the squeeze plate and the pivoted squeeze plate in response to these signals.

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method
14. (amended) Apparatus according to claim 13, characterized in that a number of operator selectable or automatically selectable predetermined velocity versus time profiles for the squeeze plate and the pivoted squeeze plate are stored in the controller.

method
15. (amended) Apparatus according to claim 14, characterized in that the controller controls the speed of the squeeze plate and the pivoted squeeze plate during the squeezing of the mould according to the speed versus time profiles stored in the controller.

16. (amended) Apparatus according to claim 11, characterized in that the first pump and the second pump are of the variable displacement type, whereby the displacement of the first pump and the second pump is set according to a respective signal from the controller.

17. (amended) Apparatus according to claim 13, characterized in that the controller, the first sensor, the first pump and the first actuator form a closed loop PID control system.

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18. (amended) Apparatus according to claim 13, characterized in that the controller, the second sensor, the second pump and the second actuator form a closed loop PID control system.

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